<b>Work Orde</b> 4 <i>pril-22-13 12:</i>	52:03 PM				*10	<b>025</b>	55*							Page	1
tem ID: Revision ID: Item Name:	D3912-041	iver Assembly	-	<del></del> -	Accept	*	1900	<b>040</b>	100	)* s	_	Start Stop	*N: *N:	S1* S2*	-
Start Date: Required Date: Reference:	4/22/13 5/03/13	Start Qty: Req'd Qty		*5* *5*			Cust Item I Customer:	D:							
- Approvals:	Process Pla			Date: 13-04-2		·		ite:		R		Start Stop	*N *N	R1* R2*	
Sequence ID/ Work Center II	D	Operation Description			Set Up/ Run Hours	·	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
Draw Nbr	Rev	vision Nbr													
D3912	В										<b>-</b> :			. 0	/
100 *100* Packaging Packaging		Pick Kit	lemo		0.00					5×	· <u>-</u>		/		3/89/
110 <b>*110*</b> Small Fab Small Fab		1-		D3912-1/-3/-5 and insta TS 1.250" LONG	0.00 0.00 Il rivets as per dwg					_5x_	- <del></del>	-		J.	, pq
					spring pin lanyard assy a	as per dwg							·		
120		QC5- Inspect	part comple	eteness to step on W/O	00.00 <b>CAC</b>					5					
*120* QC Quality Control		M	lemo		0.00 <b>27</b> 9-89	6				. •		-	-	<u> </u>	

												. •
										DQA:	Date:	
NCR:	/es	/ No				WORK ORDER NON-C	ONFO	RMANCE / UPD	ATE			
								<u>-</u>		QA Closed:	Date:	
Vork Ord	∍ŕ:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	Ī
						Rework		Skid-tube	Crosstube	]	Water Jet	Engineering
Part I	No.					Scrap	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•	-		· <u>·</u>		Use-as-is	The	rmoforming	Finishing	Rec/Stor	re/Packaging	Other
NCR I	No.		<u>-</u>		<del></del>	Work Order Update		Large Fab	Composite	]	Supplier	
Root					Des	scription of work order update	Initial	Actio		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chief E	ng Descrip	otion	Date	Verification	QC Inspector
oc/Data												
quip/Tooling										<u>j</u>		
perator	Щ											
laterial	Ш											
etup				1								
ther	Ш		1									
rocess												
upplier	Щ											
raining	Ш			Ì								
napproved		L				·	<u></u>		<del></del>			
							AULT CA	regory				
Landi	_	1				General	_		_	7	r	
		Bending				Bend	Grai	า	_	Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	O/S	BOM/Route	Hard			Over/Under	<b> </b>	Temperature/Cure
		Cracks				Broken/Damaged	— `	ction Incomplete		Part Incorred	<del> </del>	Weld
		Crushed/	Crimped			Burrs		uctions Incomplete/Un	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination	∭Mai⊧	itenance		Part Moved		
		Heat Trea	at			Countersink	☐ Misla	beled	L_	Positioned V	_	,
		Inspection	n Strip in	Tube		Cut Too Short	Misr	ead		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes	Offse	t		<u>.</u>		
		Torque W	vaves in l	Extrusio	n	Drawing	Out	of Calibration				
		Turning S	equence	<b>:</b>		Finish	Out	of Sequence				
		Wave/Tw	ist in Tul	be		Folio	Outs	ide Dimensions				

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Quality Control

Page 2

April-22-13 12:52:03 PM Item ID: D3912-041 Accept \*N900040100\* Setup Start Revision ID: Item Name: Evebolt Receiver Assembly Start Qty: 5.00 Start Date: 4/22/13 Cust Item ID: Required Date: 5/03/13 Reg'd Qty: 5.00 Customer: Reference: Run Process Plan: Approvals: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Tool 1D Reject Reject Insp. Operation Set Up/ Tool # Plan Accept Work Center ID Description Qty Code Qty Number Stamp **Run Hours** 170 Identify as per dwg & Stock Location: 57072 0.00 \*17**0**\* Packaging 0.00 Memo Packaging 180 QC21- Final Inspection - Work Order Release 0.00 \*120\* OC 0.00 Memo

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Water Jet Engineering Crosstube Skid-tube Rework Prod. Eng. Coor. Quality Small Fab Machining Scrap Part No. Rec/Store/Packaging Other Thermoforming Finishing Use-as-is Large Fab Composite Supplier NCR No. Work Order Update Action Sign & Description of work order update Initial Root QC Inspector Chief Eng Description Date Verification or Non-conformance Date Step Qty Cause Doc/Data Equip/Tooling Operator Material Setup

Landing (	Sear	General	 _		<u>.</u>	_	,
	Bending	Bend	Grain		Ovalized		Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware		Over/Under tolerance	<u> </u>	Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete		Part Incorrect		Weld
	Crushed/Crimped	Burrs	Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled
	Cuffs	Contamination	Maintenance		Part Moved		
	Heat Treat	Countersink	Mislabeled	<u> </u>	Positioned Wrong	_	•
	Inspection Strip in Tube	Cut Too Short	Misread	L.	Power Loss/Surge		Other
	Ripples in Bend	Drill Holes	Offset				
	Torque Waves in Extrusion	Drawing	Out of Calibration				
	Turning Sequence	Finish	Out of Sequence				

Outside Dimensions

**FAULT CATEGORY** 

Wave/Twist in Tube

Folio

Other
Process
Supplier
Training
Unapproved

## **Picklist Print**

April-22-13 12:52:02 PM

Work Order ID:

100255

Parent Item:

D3912-041

Parent Item Name:

Eyebolt Receiver Assembly

Start Date: 4/22/13

Required Date: 5/03/13

Start Qty: 5.00

Required Oty: 5.00

Comments:

IPP RevA: new issue DD 09.11.18 verified by:EC

IPP Rev:B 10.06.10 memo in

seq110 \*\*\*IF PLUNGER GOES IN TO DEEP, INSTALL A WASHER (AN960C516L) IF

NECESSARY BETWEEN PLUNGER AND D3912-1. YOU MAY HAVE TO ENLARGE WASHER

HOLE FOR IT TO FIT\*\*\* DD verfJLM IPP REV:C A

	HOLE FOR IT TO VERIFIED:DD	FIT*** DD veri	f:JLM	IPP REV:C	AS PER REV	В 10-08-05	JLM						
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149C0663R Washer		Purchased	No				Each	55.0000	- , <del></del>	5	///	69 1	)- · 06
Washer				Location ST292	<b>8</b> 0.2	<u>Loc Otv</u> 55 55		c Code			- (S	jorj.	
<b>D3912-1</b> Eyebolt		Manufactured	No	7104	073	100	Each	16.0000	1	5 	J.S.	3/09	06_
ı	ż	,		Location ST144 770' 937		Loc Otv 16 2	<u>L.c</u>	e Code				/ /	/ /
D3912-3 Eyebolt Block		Manufactured	No			100	Each	41.0000	2	10 	B	3 /07	66_
e e				Location ST144 8820 9180 9760 991	65 89	Loc Otv 3 6 41 7 2 12 20	\$ 102	Code 3 323	<u> </u>				/ /
D3912-5 Eyebolt Plate		Manufactured	No	771	17	100	Each	22.0000	2	10	43	2/0	7/06
				Location ST144 8330 8840 9777	06	Loc Oty 22 1 3		oc Code			] 39	972	15

										DQ	A:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	100	VFORM	MANCE / UPI	DATE	QA Close	d:	Date:	
					DISPOSITION			<del>.</del>	AGAINST DE				<del></del>
Work Orde	r:			<del></del>	Rework	1		Skid-tube	Crosstube	1	Water	Jet -	Engineering
Part N	o				Scrap		ı	Machining	Small Fab	-1	rod. Eng. Co	or.	Quality
NCR No.					Use-as-is Work Order Update	Thermoforming Finishing Large Fab Composite			~ <del>-</del>	Rec/S	tore/Packag Supp		Other
Root				Descri	ption of work order update	1	nitial	Act	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verific	ation	QC inspector
Doc/Data											İ		
Equip/Tooling						1							
Operator [										i			
Material [													
Setup													
Other		1	1										
Process			1										
Supplier													
Training			]										
Unapproved													·
· · · · · · · · · · · · · · · · · · ·		<del></del>			F.	AUL	T CATE	GORY					
Landir	ng Gear				General		_		_	=			•
	Bending				Bend		Grain			Ovalized			Pressure/Forced
	Centre N	ot Conce	ntric to (	o/s 🗀	BOM/Route		Hardwa	re		Over/Und	er tolerance		Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incor	rect		Weld
	Crushed	/Crimped			Burrs		Instruct	ions Incomplete/l	Unclear	Part Lost/	Missing		Wrong Stock Pulled
	Cuffs			1	Contamination		Mainte	nance		Part Move	ed		
	Heat Tre	at			Countersink		Mislabe	led	[	Positione	d Wrong		_
	Inspection	n Strip in	Tube	<u> </u>	Cut Too Short	$\Box$	Misread	1		Power Lo	ss/Surge		Other
	Ripples i	•			Drill Holes		Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

April-22-13 12:52:03 PM

Work Order ID:	100255							
Parent Item:	D3912-041					Start	Date: 4/22/13	Required Date: 5/03/13
Parent Item Name:	Eyebolt Receiver Assembly					Star	<b>Qty:</b> 5.00	Required Ory: 5.00/
D3801-I Hand Retractable Spring	Manufactured Plunger	No		1	Each	19.0000	-	5 /50/09/06
		<u>Loc</u> STO	ation 44	<u>Loc Oty</u> 19		Loc Code		103556
		310	99271	19				_ _
MS20615-4M20 RIVET	Purchased	No		100	Each	95.0000	8	40 8 53/09/06
		<u>Loc</u>	<u>ation</u>	Loc Qtv		Loc Code		
	_	GA	119546 120644 121339 121463 122807	95 26 7 9 32 21				M125567
MS21209-F615 Heli-Coil	Purchased	No		I	Each	96.0000		5 3./09/06.
			<u>ation</u>	Loc Oty		Loc Code		
		GA	121561 125097 <b>-</b>	96 2 94			<u></u>	_ _

										DQ	A.	Date:	
NCR: Y	es / No				WORK ORDER NON-	100	VFORM	MANCE / UP	DATE	QA Close	 ed:	 Date:	
	<u>-</u> .	<u> </u>	<del></del> .		DISPOSITION			<del>-</del> "	AGAINST DE				_
Work Orde	r:					, [		er		1		Water Jet	l Farinassina[
Part N	0		<u></u>		Rework Scrap Use-as-is		f	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	4		Eng. Coor.	Engineering Quality Other
NCR N	0				Work Order Update	<u> </u>		Large Fab	Composite	, Kec/s	tore	Supplier	
Root				Descri	ption of work order update	Π	Initial	Ac	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date		Verification	QC Inspector
Doc/Data		Ī											
quip/Tooling													
Operator		1				Ì				İ	1		
Material [											- 1		
Setup [				Ì		1				į	-		
Other	_			1		İ							
rocess						1					.		1
Supplier		1	1							İ	1		
Fraining		1					:	:					
Jnapproved													<u> </u>
<u>-</u>				-	F	ΑUL	T CATE	GORY					
Landir	ng Gear				General		_		-	_			•
	Bending				Bend		Grain			Ovalized			Pressure/Forced
Ţ	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re	[_	Over/Und	der to	olerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incor	rrect		Weld
	Crushed	/Crimped			Burrs		instruct	ions Incomplete/	Unclear	Part Lost/	/Miss	sing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Mov	ed		
	Heat Tre	at			Countersink		Mislabe	eled		Positione	d Wr	rong	_
	Inspection	n Strip in	Tube	<u> </u>	Cut Too Short	Г	Misread	1		Power Lo	ss/Su	urge	Other

Offset

Out of Calibration Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Drill Holes

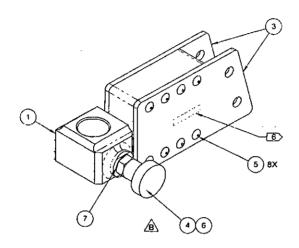
Drawing

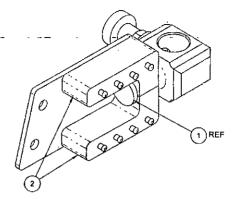
Finish

Folio

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ITEM	QTY -041	P/N	DESCRIPTION	
	x	D3912-041	EYEBOLT RECEIVER ASSY	
1	1_1	D3912-1	EYEBOLT	
2	2	D3912-3	EYEBOLT BLOCK	
3	2	D3912-5	EYEBOLT PLATE	
4	1	D3801-1	SPRING PLUNGER	B
_ 5	8	MS20615-4M2G	RIVET -	
6	_1	MS21209-F615	HELICAL	
7	1	NAS1149F0332P	WASHER	B)
	1 2 3 4 5 6	1 1 2 2 3 2 4 1 5 8 6 1	X   D3912-041     1   1   D3912-1     2   2   D3912-3     3   2   D3912-5     4   1   D3801-1     5   8   MS20615-4M20   6   1   MS21209-F615	X   D3912-041   EYEBOLT RECEIVER ASSY     1





SUPPLEMENTAL ISO VIEW (EYEBOLT PLATE REMOVED TO SHOW INTERIOR FEATURES)

100255 ML3



## **D3912-041 EYEBOLT RECEIVER ASSY**

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NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING
FINE POINT PERMANENT INK MARKER

8

D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMY; MS21209-F615 WAS MS21209-0610 HELICAL; (1) WASHER NAS1149C0663R ADDED, BOSS ADDED TO D3912-1. 10 06 28 ٨ NEW ISSUE JPH 10.03.04 REV. DESCRIPTION βY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3912 MFG. APPR. SHEET 1 OF 3 APPROVED TITLE SCALE EYEBOLT RECEIVER ASSY DE APPR. NTS DATE 10.06.28

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